

Work Order ID 87084

87084

Page 1

July-10-12 3:04:43 PM

Item ID: D3570-1 *-Scrap* Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 7/10/12 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 8/17/12 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: *R* Date: *12-07-11* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3570	Rev E								

100 0.00

100

Waterjet

FLOW CNC Waterjet

6061 .125

FLOW WATER JET

Memo

1-Cut as per Dwg D3570

Dwg Rev: *E*

Prog Rev: *E*

GRAIN DIRECTION AS PER DWG

2-Debur if necessary

0.00

6 0 Jm 12-7-22

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

6 0 Jm 12-7-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Reference:




Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 SMB 12-7-23				6			
130 *130* Small Fab Small Fab	Small Fab Memo 1-Form as per Dwg D3570 Using DT8945 2-Cut excess materials per Dwg D3570. 3-Drill as per Dwg D3570 Using Dt8946	0.00 0.00				6	0		FF 12-08-02
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							PTC →

Dart Aerospace Ltd

W/O: 87084		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3570-1 PAR #: Fault Category: Small FA3 NCR: (Yes) No DQA: Date: 14/08/17
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: Date: 12/08/20

NCR: 12-1708		WORK ORDER NON-CONFORMANCE (NCR) \$5.42 X 6 = \$32.52						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
21/06/18	#130	Found at inspection that Qty X 6 (all) are Bent incorrectly. Parts measure 3.585" should be 3.464" ± 0.030"	 057012 12/06/18	Scrap + Destroy Qty 6 (all) no Rephe	FF 12-08-13	SB 12/08/13	 057012 12/08/18	 12/08/18
		2.c.						

NOTE: Date & initial all entries

Work Order ID 87084***87084***

Page 3

July-10-12 3:04:43 PM

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 7/10/12

Start Qty: 6.00

6

Cust Item ID:

Required Date: 8/17/12

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

160

Powdercoat

Memo

0.00

Powder Coating

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 8/17/12

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location: _____

0.00

180

Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

8/12-08-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

July-10-12 3:04:42 PM

Page 1

Work Order ID: 87084

Parent Item: D3570-1

Start Date: 7/10/12

Required Date: 8/17/12

Parent Item Name: Bracket

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-01-30 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No			100	sf	30.6881	0.07	0.4421052 0.5			Jm 12-7-22
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT021		30.6880789							
				121473		30.6880789				121473			

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	87084
Description: Bracket		Part Number:	D3570-1
Inspection Dwg: D3570 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.209	+0.005/-0.001	0.210"	✓		U	mm01
2.25	+/-0.030	2.257"	✓		U	"
4.75	+/-0.030	4.752"	✓		✓	"
0.359	+/-0.010	0.361"	✓		✓	"
0.557	+/-0.010	0.558"	✓		✓	"
1.943	+/-0.010	1.945"	✓		✓	"
2.141	+/-0.010	2.144"	✓		✓	"
0.533	+/-0.010	0.535"	✓		✓	"
1.939	+/-0.010	1.942"	✓		✓	"
0.311	+/-0.010	0.313"	✓		✓	"
1.717	+/-0.010	1.719"	✓		✓	"

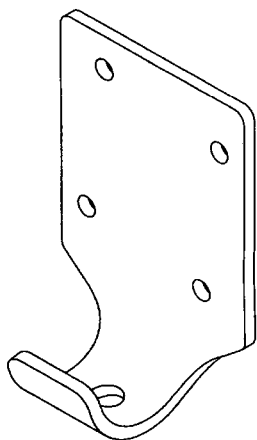
Measured by:	Jm
Date:	12-7-22

Audited by:	SNB DAS
Date:	12-7-23

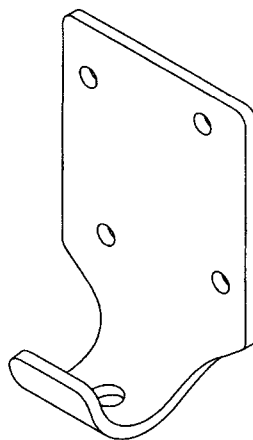
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
b	09.05.07	Dwg Rev updated	KJ/EC	

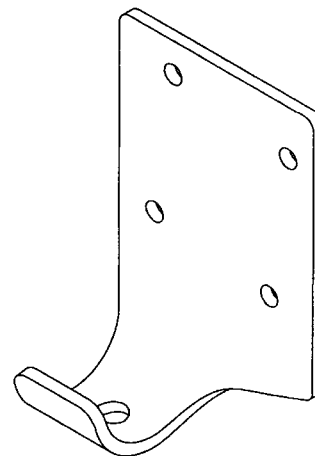
87089
P 1207-11



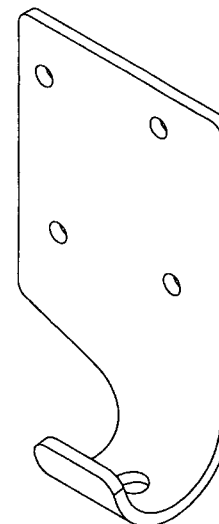
D3570-1 BRACKET



D3570-2 BRACKET



D3570-3 BRACKET



D3570-4 BRACKET

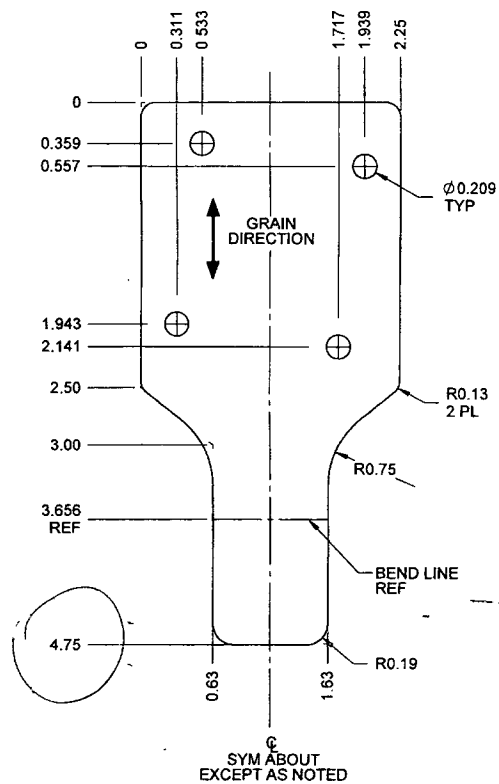
RELEASED
09/04/22

NOTES:

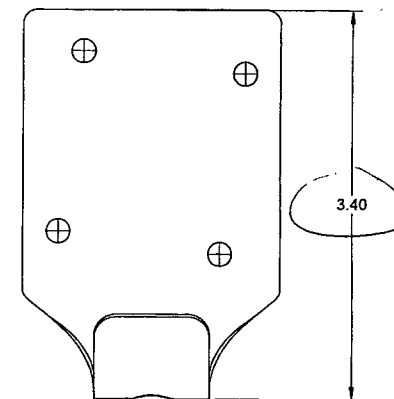
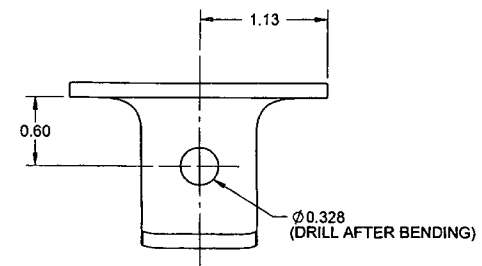
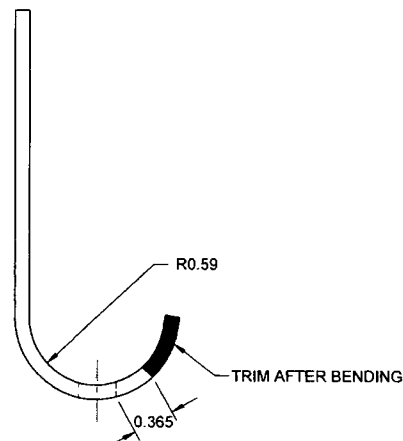
- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3570-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs EACH

REV	DESCRIPTION	BY	DATE
E	SHEET 3 UPDATED D3570-3F FLAT PATTERN, SEE REV D FOR DETAILS SEE PAR 09-014.	AJS	09.04.22
D	ADDED -3 & -4 FOR USE ON 214B/B1. SEE PAR 09-014.	AJS	09.04.01
C	UPDATE DIMS FOR CLARITY	LE	07.06.01
B	CHANGE BEND RAD TO 0.60 FROM 0.50	LE	07.04.16
A	NEW ISSUE	LE	07.02.07

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. E
MFG. APPR.	AJS	D3570	SHEET 1 OF 5
APPROVED	AJS	TITLE	SCALE
DE APPR.	AJS	BRACKET	NTS
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D3570-1F FLAT PATTERN



D3570-1 BRACKET
(MAKE FROM D3570-1F)

RELEASED
29/04/13

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3570	SHEET 2 OF 5
APPROVED		TITLE	SCALE
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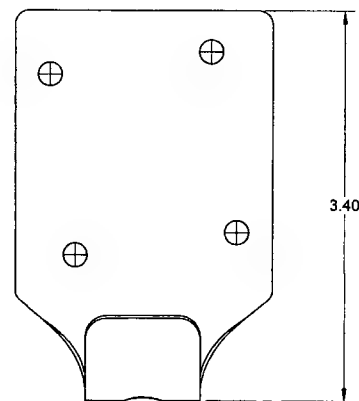
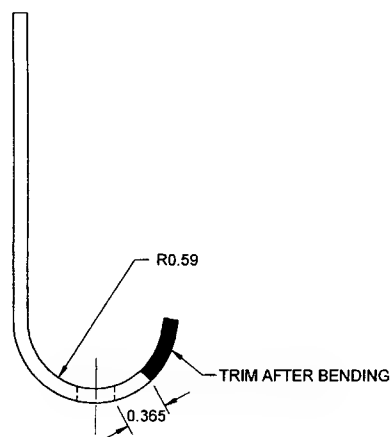
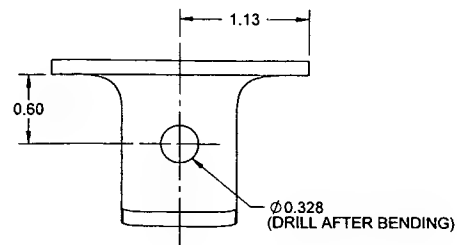
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3570-2 BRACKET
(MAKE FROM D3570-1F)

8-7084

RELEASED
09/04/22

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	E	D3570	SHEET 3 OF 5
APPROVED	140	TITLE	SCALE
DE APPR	A	BRACKET	NTS
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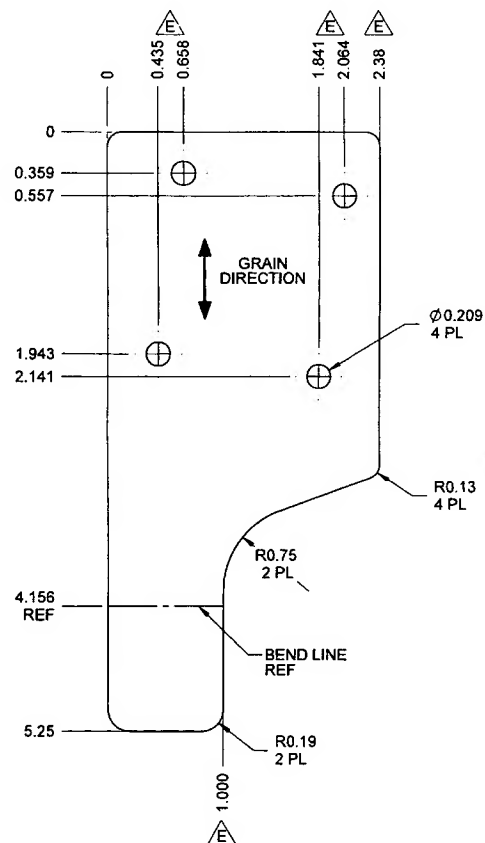
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

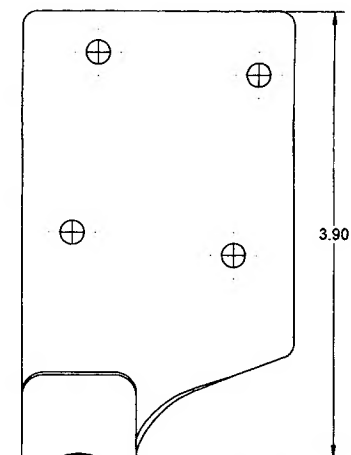
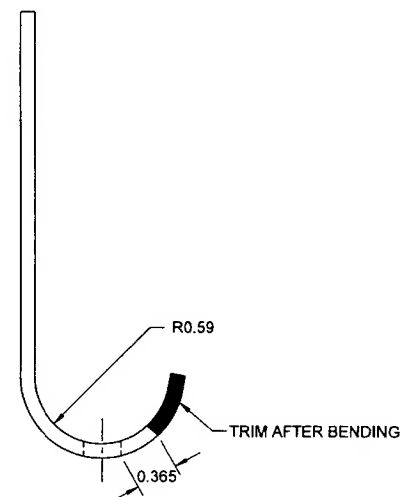
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3570-3F FLAT PATTERN



D3570-3 BRACKET
(MAKE FROM D3570-3F)

RELEASED
07/24/23 MB

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3570	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
DATE	09.04.22	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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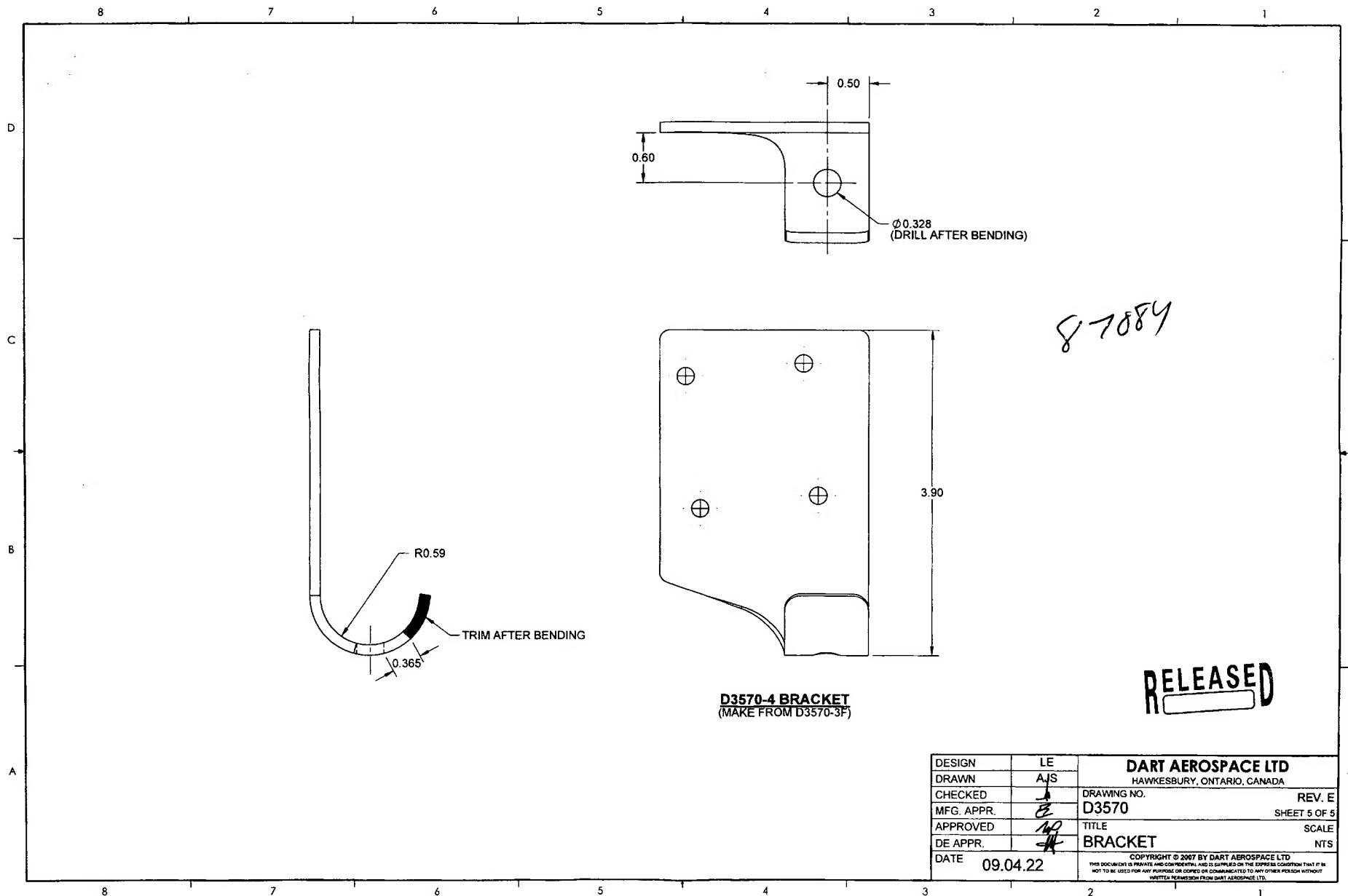
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